

Technical Data Sheet

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- Properties:** AKEPOX® 5000 is a liquid, solvent-free, two-component adhesive based on an epoxy resin containing a cycloaliphatic polyamine hardener. The product characterized by the following properties:
- very neutral colour
 - very low tendency to yellowing
 - very low shrinkage during hardening, therefore minimal tension within the bonding layer
 - weather-resistant bondings
 - can be excellently coloured with AKEPOX® colouring pastes or concentrates
 - the bonding layer retains its form well
 - low tendency to fatigue
 - very high stability towards alkalis and is therefore very suitable for bondings with concrete
 - free of solvents, therefore it is especially suitable for bonding materials which are impermeable to gas
 - excellent laminating resin for making of sandwich parts
 - adheres well to stone even if it is slightly damp
 - suitable for bonding materials which react in contact with solvents (e.g. polystyrene, ABS)
- Application Area:** AKEPOX® 5000 is mainly used in the stone-working industry for the weather-resistant bonding and gluing of natural stone (marble, granite), Techno Ceramics as well as artificial stone or building materials (terrazzo, concrete). By means of the application of high-quality raw materials it was possible to develop a system which hardly yellows. It is thus possible to use it in combination with light-coloured or even white natural stone without the usual intensive yellowing of conventional epoxy-resin systems. The low viscous consistency enables very thin adhesive joints. In combination with spun glass fabrics even lamination can be done. Other materials can also be glued with AKEPOX® 5000, e.g. plastics (hard PVC, polyester, polystyrene, ABS, polycarbonates), paper, wood, glass and many other materials. AKEPOX® 5000 is not suitable for the gluing of polyolefin (polyethylene, polypropylene), silicones, hydrocarbon fluorides (teflon), soft PVC, soft polyurethane, butyl rubber and metal.
- Instructions for Use:**
1. Thoroughly clean and slightly roughen surfaces to be bonded.
 2. Two parts by weight or volume of Component A are to be thoroughly mixed with one part by weight or volume of Component B until a homogeneous shade of colour is achieved.
 3. AKEPOX® colouring pastes or colouring tints can be used for colouring if required (max. 5%).
 4. The mixture remains workable for approx. 20 - 30 minutes (20°C). After 6 - 8 hours (20°C) the bonded parts may be moved, after 12 - 16 hours (20°C) approx. they may be further processed. Max stability after 7 days (20°C).
 5. Tools can be cleaned with AKEMI® Nitro Thinner.
 6. Warmth accelerates and cold retards the hardening process.
- Special Notes:**
- Suitable for bonding of load-bearing construction parts, however, the relevant standards such as DIN 18516 part 1 and part 3 or DIN 2304 must be observed during application.

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- The optimal mechanical and chemical properties can only be attained by adhering to the exact mixing proportions; excess adhesive or hardener has the effect of a plasticizer.
- Use separate vessels when component A and B are being extracted from their containers.
- The resin is no longer to be used if it has already thickened or is jellying.
- The product is not to be used at temperatures below 10°C because it will not sufficiently harden.
- At constant temperatures above 50°C the hardened adhesive tends to yellow.
- The hardened resin can no longer be removed by means of solvents. This can only be achieved mechanically or by applying higher temperatures (> 200°C).
- Component A slightly tends to crystallize (honey effect). The product can be made workable again by warming it up.
- The stability of the bonding is highly dependent upon the natural stone which is to be bonded: silicate-bound stones react better than carbonate-bound stones.

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1. Colour:

	comp. A: colourless to slightly yellow transparent
	comp. B: colourless to slightly yellow transparent
2. Density:

	comp. A: approx. 1.15 g/cm ³
	comp. B: approx. 1.10 g/cm ³
3. Working time:

a) mixture of 100 g component A + 50 g of component B:	at 10°C: 60 - 70 minutes
	at 20°C: 20 - 30 minutes
	at 30°C: 15 - 20 minutes
	at 40°C: 5 - 10 minutes
b) at 20°C and varying amounts:	
20 g comp. A + 10 g comp. B:	35 - 45 minutes
50 g comp. A + 25 g comp. B:	25 - 35 minutes
100 g comp. A + 50 g comp. B:	20 - 30 minutes
300 g comp. A + 150 g comp. B:	15 - 25 minutes
4. Hardening process (shore D-hardness) of a 2 mm layer at 20°C:

<u>3 hrs</u>	<u>4 hrs</u>	<u>5 hrs</u>	<u>6 hrs</u>	<u>7 hrs</u>	<u>8 hrs</u>	<u>24 hrs</u>
--	30	51	67	74	76	81
5. Mechanical properties:

Bending strength DIN EN ISO 178:	60 - 70 N/mm ²
Tensile strength DIN EN ISO 527:	30 - 40 N/mm ²
6. Chemical resistance:

Water absorption DIN 53495:	< 0.5%
Sodium chloride solution 10%:	stable
Salt water:	stable
Ammonium 10%:	stable
Soda lye 10%:	stable
Hydrochloric acid 10%:	stable
Acetic acid 10%:	conditionally stable

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Formic acid 10%:	conditionally stable
Petrol:	stable
Diesel oil:	stable
Lubricating oil:	stable

Storage: If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 24 months from production.

Health & Safety: Read Safety Data Sheet before handling or using this product.

Important Notice: The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.

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